



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-04-1
Job Sheet 187728



Part No: 20NR-04-1

Job Qty: 6 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/12/18

Job Tracking No:

Due Date: 12/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-04 Rev 6 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/31/18	0.00	0.00	Start Up Machining-4		
100	Mill Conv	6 pcs		12/31/18	0.50	1.20	Mill Conv 2		
110	QC	6 pcs		12/31/18	0.00	0.00	QC2 Machining-5		
120	QC	6 pcs		12/31/18	0.00	0.00	QC8 Machining-5		
130	Packaging	6 pcs		12/31/18	0.00	0.00	Packaging3-2		
140	QC21-SA	6 Ea		12/31/18	0.00	0.00	QC21		

Part Op 100 - 1- Jig in drawer 185 (DT10383) 2-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate clockwise to the end of stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic engraver as per DWG.
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-1127-020	Solenoid	6 Ea (1 ea)	90-Start up Operation	S070448 GA196F

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-1127-020	6	37	0

Part Specifications

Specifications could not be found.



Container No: S142326



Part: 20NR-04-1

Job No: 187728

Serial No/Batch: S142326

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 12/12/18 1:48 PM Dart.lajeunesse.marie

Date: 01/07/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

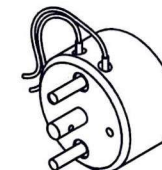
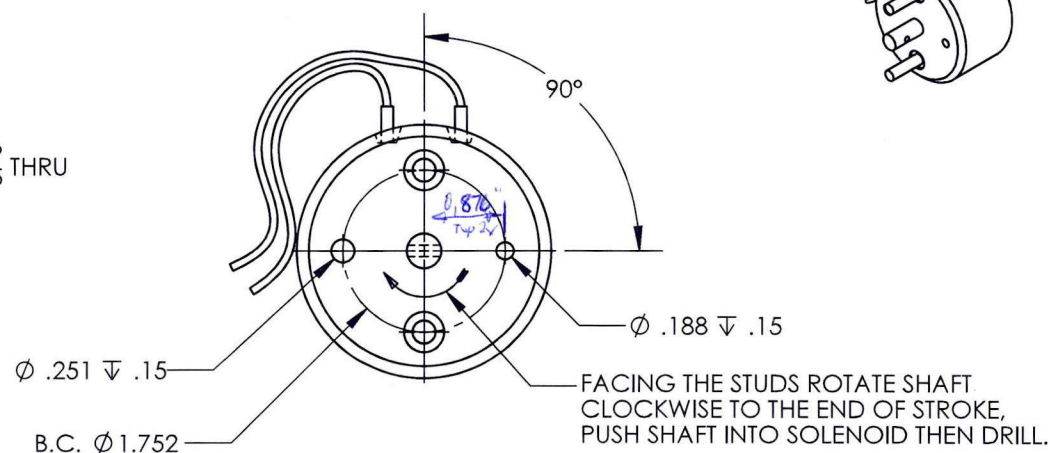
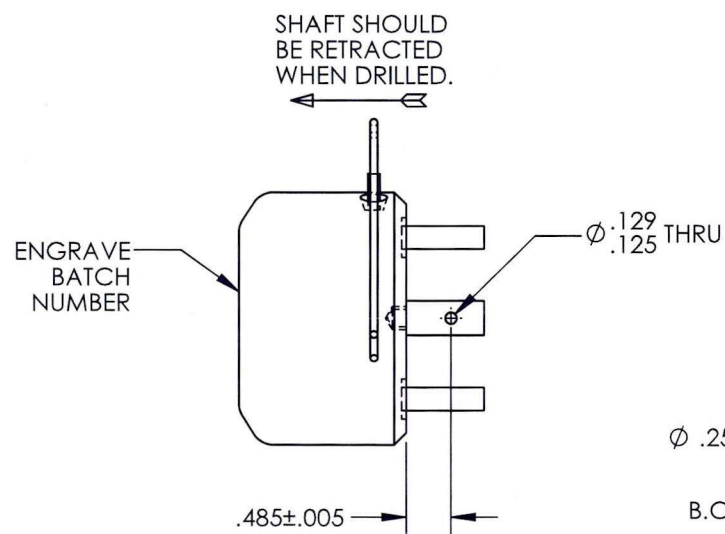
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	14-0206	20NR-04-1 ADDED ENGRAVE BATCH # NOTE.	11/3/2014	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187728115
1872-12

20NR-04-1

SOLENOID

DART AEROSPACE	
TITLE SOLENOID	
DWG NO. 20NR-04-1	REV 6
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/1/1995
SHEET 2 OF 3	